

Work Order ID 131746

131746

Page 1

Tuesday, April 21, 2015 1:48:47 PM

Item ID: D2344 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Deck Plate Aft
Start Date: 4/20/15 Start Qty: 4.00 *4* Cust Item ID:
Required Date: 4/20/15 Req'd Qty: 4.00 *4* Customer:
Reference:

Approvals: Process Plan: MLJ Date: 15-04-22 Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2344	Rev F								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per dwg prog rev: <u>F</u> dwg rev: <u>F</u>								
	2-deburr as required								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

(4)

12/15/04/29

(4)

12/15/04/29

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Tuesday, April 21, 2015 1:48:47 PM

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Page 2

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 4/20/15 **Start Qty:** 4.00 ***4***

Cust Item ID:

Required Date: 4/20/15 **Req'd Qty:** 4.00 ***A***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run** **Start** ***NR1***
 QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							38 9-89
120						(4)			
QC	Memo	0.00							APR 29 2015

130		0.00	
130	Small Fab		<i>4X</i> <i>15/04/30</i> 36 9-89
Small Fab	Memo	0.00	
Small Fab	1-Deburr sharp edges 2-Countersink holes per Dwg D2344		

140	QC5- Inspect part completeness to step on W/O	0.00	38 9-89 4
1 40			
QC	Memo	0.00	
Quality Control			APR 30 2015

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Picklist Print

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Parent Item: D2344

D2344

Parent Item Name: Deck Plate Aft

Start Date: 4/20/15

Required Date: 4/20/15

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev:D00.06.26Removed P/O for powder coatEC

IPP Rev:E 07-07-04 Asper Rev F JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased		No		100	sf	198.6680	0.745	4			

M2024T3S 063

2024-T3 .063 sheet

D215/04/29

Location

Loc Qty

Loc Code

MAT022

198.668

m127866

16

m130525

182.668

3.5

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Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐				Part Incorrect ☐	
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐				Part Lost/Missing ☐	
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐				Part Moved ☐	
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐				Drawing ☐	
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐				Finish ☐	
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐				Misread ☐	
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐				Turning Sequence ☐	
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

DART AEROSPACE LTD		Work Order: 131746
Description: Litter Deck Plate Kit (350)		Part Number: D2344
Inspection Dwg: D2344	Rev: F	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

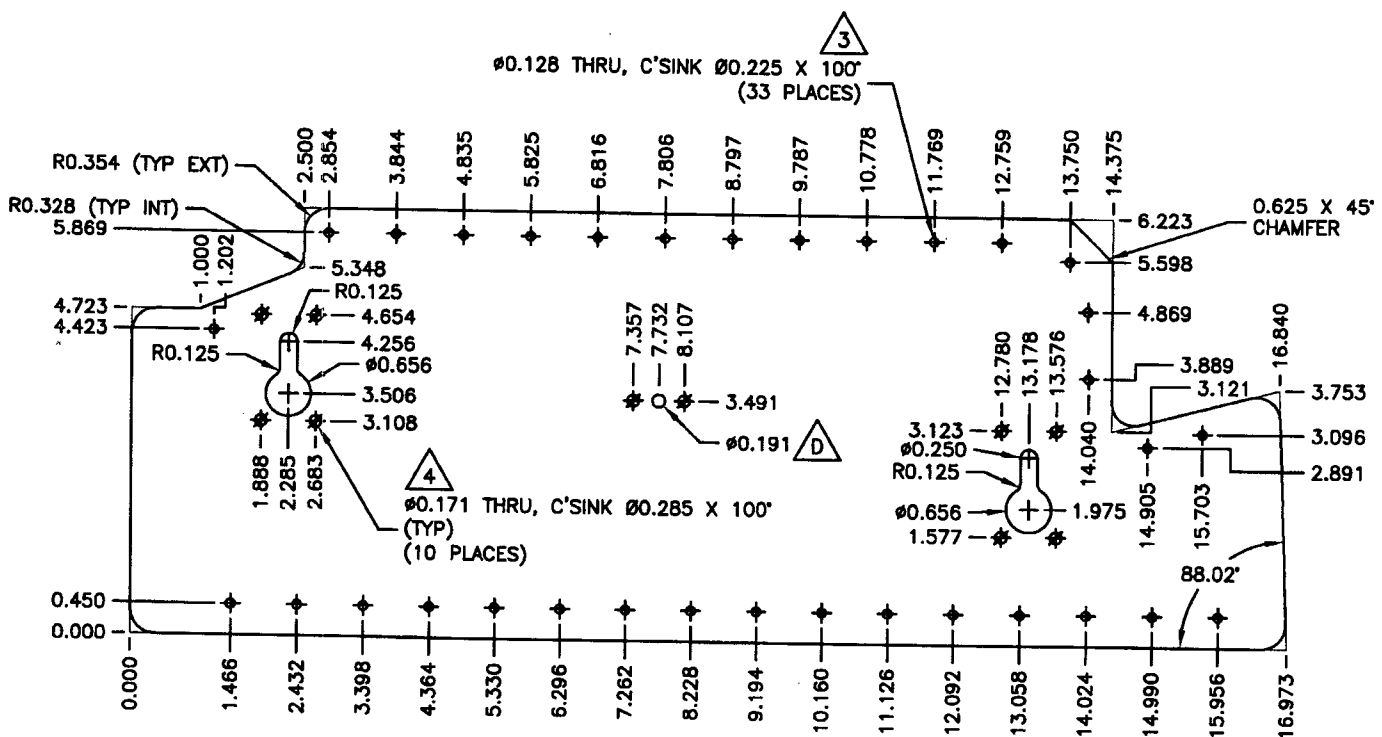
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.223	+/-0.010	6.227	/			
5.598	+/-0.010	5.602	/			
4.869	+/-0.010	4.873	/			
3.889	+/-0.010	3.891	/			
3.096	+/-0.010	3.096	/			
2.891	+/-0.010	2.892	/			
16.973	+/-0.010	16.975	/			
0.450	+/-0.010	.452	/			
4.423	+/-0.010	4.422	/			
4.723	+/-0.010	4.725	/			
1.202	+/-0.010	1.203	/			
5.869	+/-0.010	5.873	/			
4.654	+/-0.010	4.655	/			
Ø0.656	+0.005/-0.000	Ø.655	/			
1.888	+/-0.010	1.890	/			
2.285	+/-0.010	2.287	/			
2.683	+/-0.010	2.687	/			
Ø0.171	+0.005/-0.000	Ø.171	/			
3.491	+/-0.010	3.494	/			
Ø0.191	+0.005/-0.000	Ø.191	/			
3.123	+/-0.010	3.125	/			
1.975	+/-0.010	1.978	/			
Ø0.128	+0.005/-0.001	Ø.127	/			

Measured by:		Audited by: DAS 38	Prototype Approval:	N/A
Date:		Date: APR 29 2015	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue P/O D350-616-015	KJ/JLM	
B	07.07.17	Dwg Rev. updated	KJ/JLM	
C	07.09.06	Dimensions updated per Dwg. Rev. F	KJ/JLM	

DART

DESIGN KE	DRAWN BY JC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JB	APPROVED H	DRAWING NO. D2344	REV. F SHEET 1 OF 1
DATE 07.06.07		TITLE LITTER DECK PLATE, 350	SCALE 1:3
A	95.01.14	NEW ISSUE	
B	95.02.09	MOVED KEY HOLES	
D	95.03.06	0.191 WAS 0.197	
E	98.06.19	0.063-0.071 THICK WAS 0.071 (TSR A371)	
F	07.06.07	C'SINK Ø0.285 WAS Ø0.308	

**D2344 LITTER DECK PLATE, 350**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063-0.071 THICK PER QQ-A-250/4 (REF. DART SPEC. M2024T3S)
- 2) FINISH: POWDER COAT BLACK SANDTEX (REF. 4.3.5.7) PER DART QSI 005 4.3
- 3) COUNTERSINK HOLES MARKED $\star$ TO Ø0.225 X 100"
- 4) COUNTERSINK HOLES MARKED $\star$ TO Ø0.285 X 100"
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 8) IDENTIFY WITH DART P/N "D2344" USING WHITE PAINT MARKER

RELEASED

07.06.02

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